

Date: Wednesday, 5/31/2006 7:40:26 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SUPPORT BRACKET
Job Number : 27309	
Estimate Number : 10260	
P.O. Number : NIA	Part Number : D23623
This Issue : 5/31/2006 S.O. No. : NIA	Drawing Number : D2362 REV E1
Prsht Rev. : NC	Project Number : N/A
First Issue : NIA Type : MACHINED PARTS	Drawing Revision : E1
Previous Run : 25451	Material : NIA
Written By : SEE COMMENT Below	Due Date : 6/25/2006
Checked & Approved By : [Signature] 06-05-31	Qty : 20 Um : Each
Comment : Est: G 00.0518 Added inspection level 8 EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D2265	Step Support Casting
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

Step Support

Pick:

Qty	Part Number	Description	Batch
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1	D2265	Step Support	B25401
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MS 06/06/02

20
20

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: Machine per folio D2362-3

JL 06/06/02 20

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: Inspect Level 2

JL 06/06/02 20

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

MS 06/06/02 20

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr

JL 06/06/02 20

6.0	POWDER COATING	POWDER COATING
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Comment: POWDER COATING

Powder Coat Gloss White (Ref 4.3.5.1) as per Dart QSI 005 4.3

A.M 06-06-06

(20)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA:  Date: 06/06/08

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Wednesday, 5/31/2006 7:40:27 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SUPPORT BRACKET

Job Number: 27309

Part Number: D23623

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

2606-07 (20)

8.0

D23971

Rubber Cushion



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Rubber Cushion

Pick:

Qty Part number

Description

Batch

1

D2397-1

Rubber

(10) B27312 (10) B 27401

9.0

D23973

Rubber Cushion



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Rubber Cushion

Pick:

Qty Part number

Description

Batch

1

D2397-3

Rubber

(10) B27313 @ B 27402

SB 06/04/07 (20)

10.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Bond rubber D2397-1 followed by D2397-3 using contact cement
as per Dwg D2362

Batch M16194

m.p. 06/06/07 (20)

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

2606-07 (20)

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

57172

06/06/08 (20)

13.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/06/08 (20)

Job Completion



06/06/08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

DART AEROSPACE LTD		Work Order:	27309
Description: Step Support Bracket		Part Number:	D2362-3
Inspection Dwg: D2362	Rev: E1	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.257	+0.005 -0.000	260	✓			
3.074	+/-0.010	3.074	✓			
0.34	+/-0.030	335	✓			
0.77	+/-0.030	768	✓			
1.500	+/-0.010	1.500	✓			
1.000	+/-0.010	1.010	✓			
0.80	+/-0.030	770	✓			
1.200	+/-0.010	1.210	✓			
1.28	+/-0.030	1.265	✓			
1.000	+/-0.010	1.030	✓			
0.75	+/-0.030	775	✓			
1.88	+/-0.030	1.877	✓			

Measured by: J.L.	Audited by: MS	Prototype Approval:	N/A
Date: 06/06/02	Date: 06/06/02	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	03.10.07	New Issue	KJ/RF	TF

DART



RELEASED
98.12.14 KE

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	REV. E
BW	CP		
CHECKED KE	APPROVED CP	DRAWING NO. D2362	SHEET 1 OF 3
DATE 98.12.04	TITLE STEP SUPPORT BRACKET	SCALE 1:2	
A	95.02.15	NEW ISSUE	
B	95.03.22	CHANGED RUBBER TO D2397	
C	96.01.22	ADD D2362-5	
D	97.05.21	ADD D2362-7	
E	98.12.04	REDRAWN, ADD 2397-5	

UNDER REVIEW

02.03.15 CP

DESIGN OK, BUT CHECK WITH
3D BEFORE MANUFACTURE
OK 06/11/07

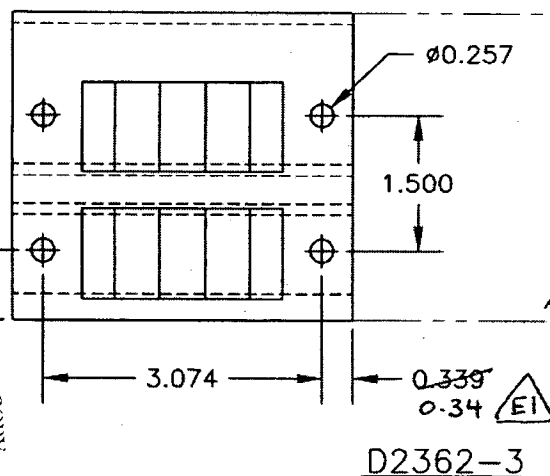
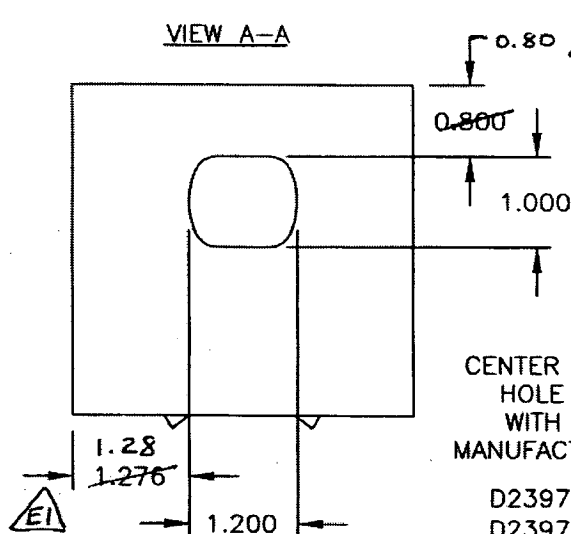
0.257 X 0.75 SLOT

REMOVE TIPS
FROM CASTING
MAX 0.080

CENTER D2397-1/-3 RUBBER
HOLE WITH SLOT AND BOND
WITH CONTACT CEMENT PER
MANUFACTURER'S SPECIFICATION

D2397-1 RUBBER CUSHION (1)
D2397-3 RUBBER CUSHION (1)

VIEW A-A



D2362-3

UNCONTROLLED COPY
SUBMIT TO APPROPRIATE
ENGINEERING
RETURN TO
SHOP COPY
WITHOUT NOTICE
WORK ORDER

NOTES:

MAKE FROM D2265

FINISH: POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3 BEFORE BONDING
RUBBER IN PLACE

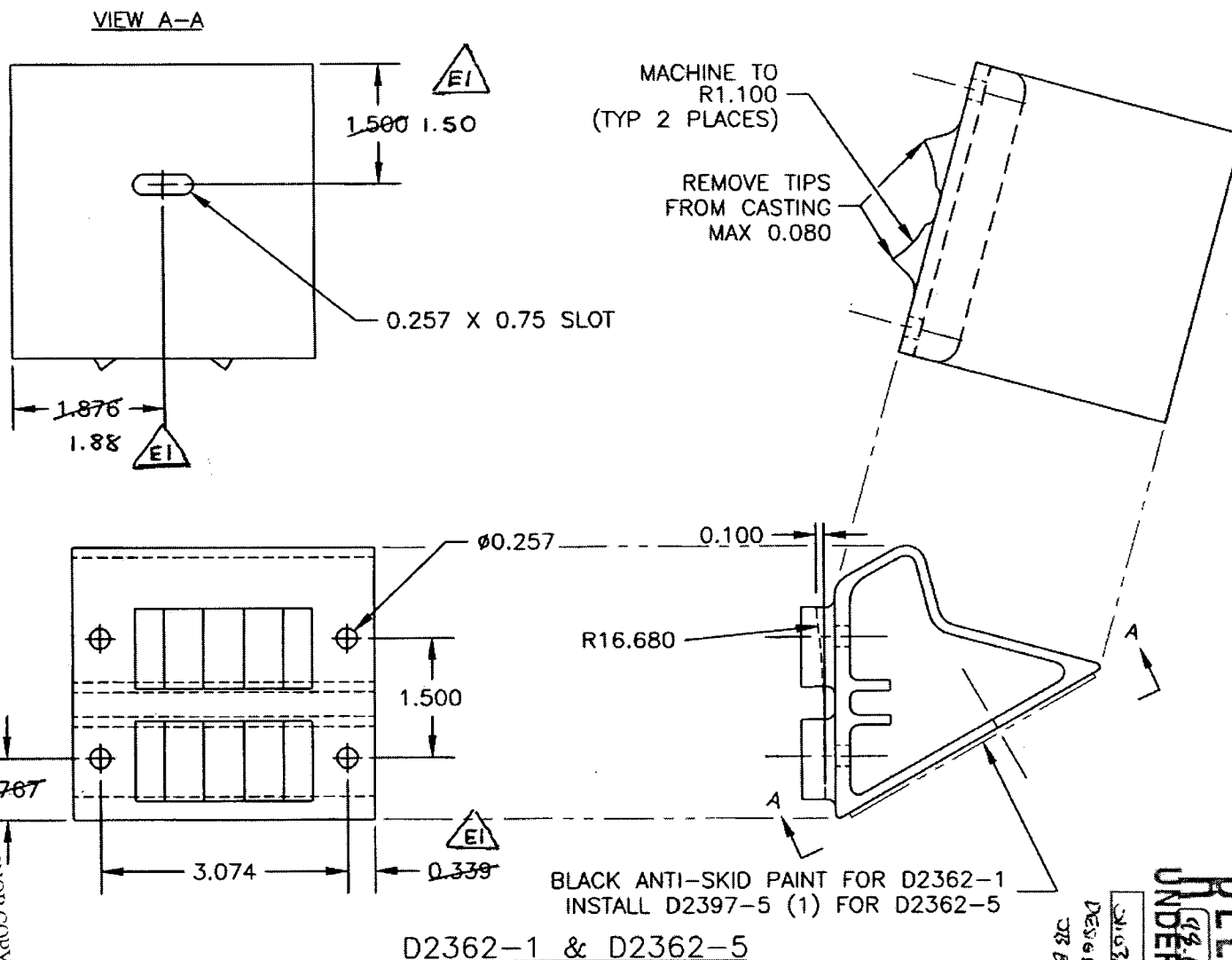
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



DESIGN	DRAWN BY	DART AEROSPACE LTD	REV. E
BW	CP	HAWKESBURY, ONTARIO, CANADA	
CHECKED KE	APPROVED JH	DRAWING NO. D2362	SHEET 2 OF 3
DATE 98.12.04	TITLE STEP SUPPORT BRACKET	SCALE 1:2	

RELEASED
98.12.14
UNDER REVIEW
KE

DESIGN OK, BUT CHECK BY
OR BEFORE MANUFACTURE
OK 12/1/05



NOTES:

MAKE FROM D2265

D2362-1: BLACK ANTI-SKID PAINT PER DART QSI 005 4.4

D2362-5: INSTALL D2397-5 RUBBER CUSHION. ALIGN RUBBER HOLE WITH SLOT AND BOND USING CONTACT CEMENT PER MANUFACTURER'S SPECIFICATION

FINISH: POWDER COAT WHITE (REF. 4.3.5.1) PER QSI 005 4.3

BEFORE ANTI-SKID PAINT OR BEFORE INSTALLING D2397-5

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

D2362-041 (SHOWN)

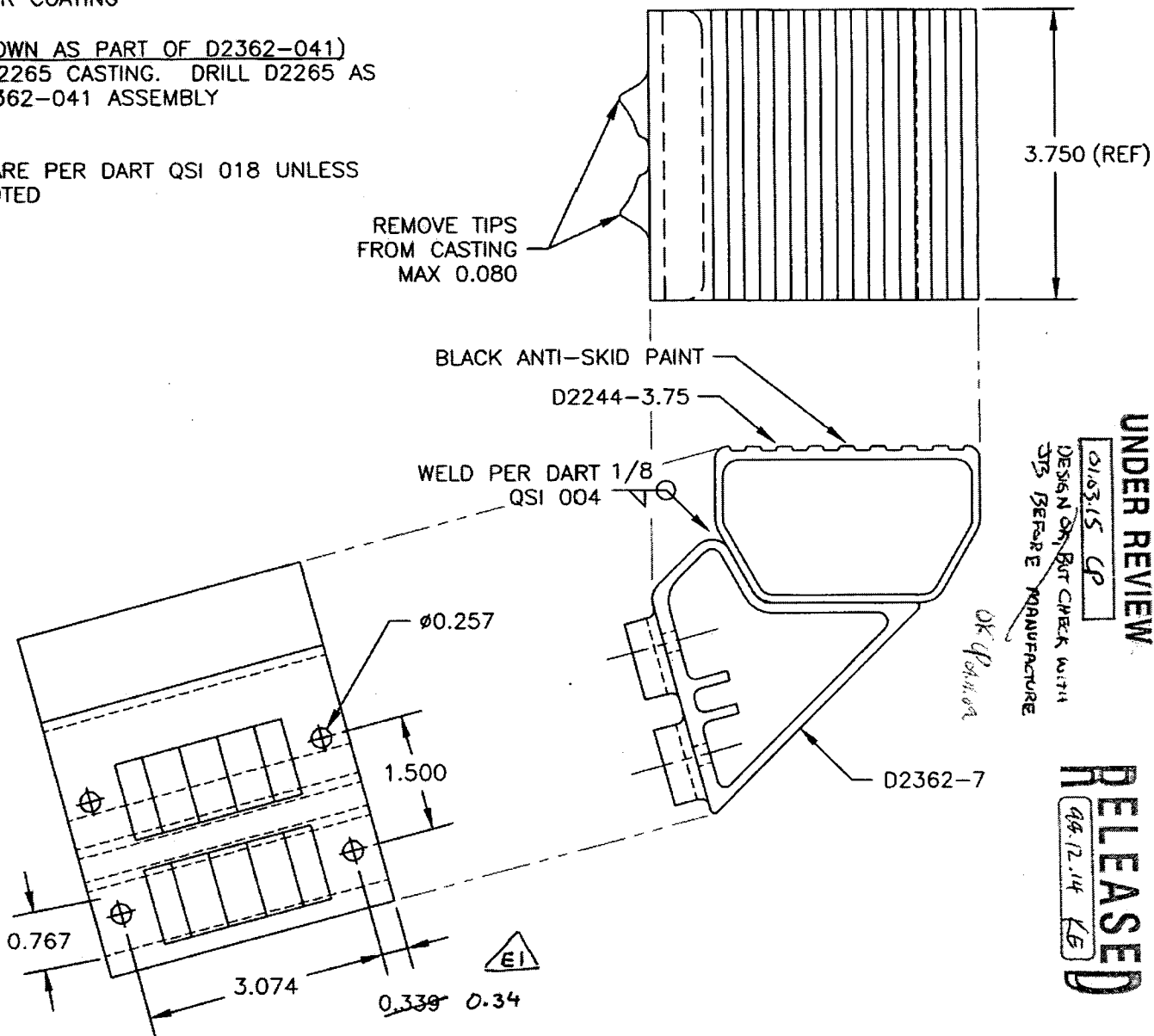
FINISH: POWDER COAT WHITE (REF. 4.3.5.1) PER
QSI 005 4.3
ANTI-SKID PAINT PER QSI 005 4.4 AFTER
POWDER COATING

D2362-7 (SHOWN AS PART OF D2362-041)

MAKE FROM D2265 CASTING. DRILL D2265 AS
SHOWN IN D2362-041 ASSEMBLY

NOTES:

TOLERANCES ARE PER DART QSI 018 UNLESS
OTHERWISE NOTED



DESIGN	DRAWN BY	DART AEROSPACE LTD
BW	CP	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
KE	KE	D2362
DATE	TITLE	REV. E
98.12.04	STEP SUPPORT BRACKET	SHEET 3 OF 3
		SCALE 1:2

UNDER REVIEW

01.03.15 CP

DESIGN OK BUT CHECK WITH
DTS BEFORE MANUFACTURE

RELEASED
98.12.14 KG